

Date: Wednesday, 1/18/2006 4:04:48 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 25556C					
Estimate Number	: 10280					
P.O. Number	: N/A			Part Number	: D3137043	
This Issue	: 1/18/2006 S.O. No. : N/A			Drawing Number	: D3137 REV E	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: E	
Previous Run	: 25457			Material	: N/A	
Written By	<u>: SEE COMMENT Below</u>			Due Date	: 2/15/2006	
Checked & Approved By	<u>: SEE ABOVE DATE &amp; USER</u>			Qty:	4 Um: Each	
Comment	: Est Rev:A 04.02.18 New issue KJ/DS					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M174B0500X02000	17-4 SS Bar	
		Comment: Qty.: 0.4875 f(s)/Unit Total : 1.9501 f(s) Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B0.500x02.000) Identify for D3124-113 3137-7 Batch: M19572	JL 06.02.18 4
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW .500 Cut blanks: (1.000" x 2.000") 5.570" long	JL 06.02.20 4
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1	
		1-Machine D3137-7 as per Folio FA3308 and Dwg D3137 Identify as D3137-7	
		2-Deburr	
		3-Scribe batch number	JL 06.02.20 4
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	JL 06.02.20 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:04:48 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 25556C

Part Number: D3137043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

M8 06/02/20 4

6.0 D31373 Guide



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D3137-3 GUIDE B25012

M8 06/02/20 4

7.0 D31375 Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D3137-5 Washer B24547

M8 06/02/20 4

8.0 MS24694S101 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 MS24694-s101 Screw M16941

M8 06/02/20 4

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3137-043 as per Dwg D3137

M8 06/02/20 4

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 06/02/20 4

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STYROS

10/2/21 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/02/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:04:48 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 25556C

Part Number: D3137043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

*TUE 06/02/22 (Y)*

*(D) 06/02/22 (P)*

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25556 C
Description: Bracket	Part Number:	D3137-7
Inspection Dwg: D3137	Rev: C2	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

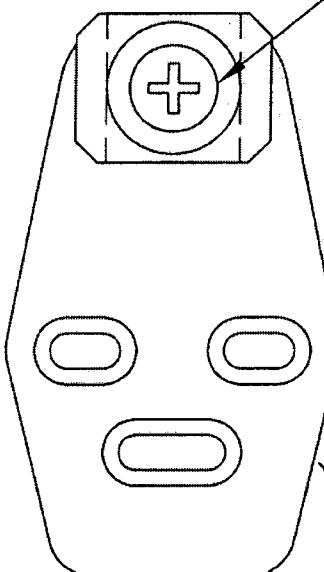
Measured by:	JL	Audited by:		Prototype Approval:	N/A
Date:	06.02.20	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3137-043	KJ/RF	
B	04.06.15	Changed & added dimensions	KJ/JLM	

**DART**

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3137	REV. E SHEET 1 OF 5
DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.17	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP.	
C	03.08.15	ADD -043	
D	04.11.03	RE-DESIGN D3137-5; CHANGE DIMS	
E	05.11.23	ADD -045	

RELEASED

05.12.09 *[Signature]*

MS24694-S101 SCREW  
D3137-5 WASHER  
D3137-3 GUIDE  
INSTALL ON SAME SIDE AS C'SINKS  
(OPPOSITE SIDE FROM RIDGES)

D3137-1 BRACKET (-041 SHOWN)  
OR  
D3137-7 BRACKET (-043 SIMILAR)  
OR  
D3137-9 BRACKET (-045 SIMILAR)

D3137-041 BRACKET ASSEMBLY (SHOWN)  
D3137-043 BRACKET ASSEMBLY (SIMILAR)  
D3137-045 BRACKET ASSEMBLY (SIMILAR)

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NO. *25556 C*



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DRAWING NO.  
D3137

REV. E

SHEET 2 OF 5

DATE

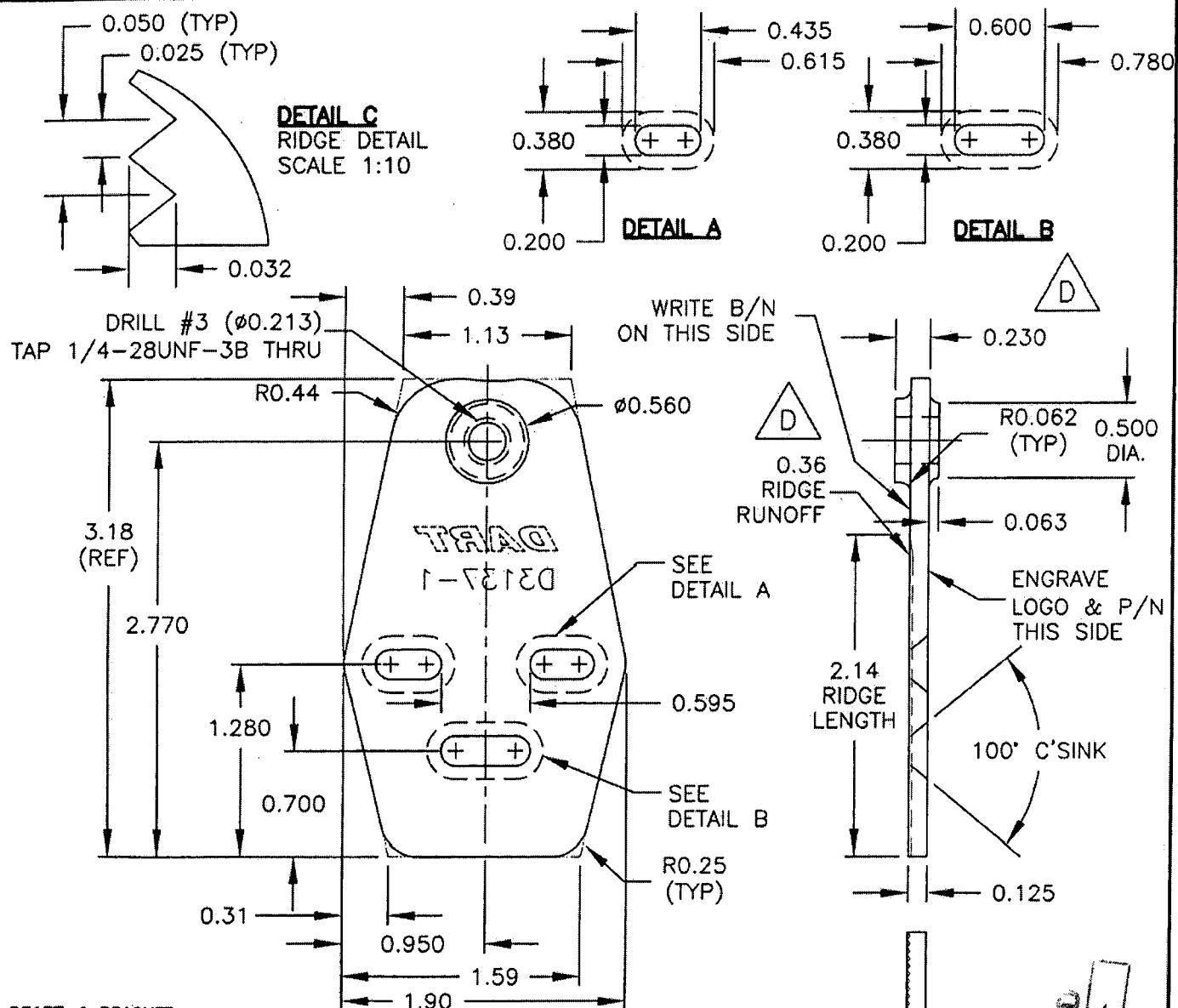
**TITLE**

**SCALE**

05.11.23

## **BRACKET ASSEMBLY**

11



**D3137-1 BRACKET**

- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
  - 2) MATERIAL: 17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
  - 3) FINISH: NONE
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
  - 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010  
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
  - 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANET INK MARKER

SEE DETAIL C

SEE DETAIL C

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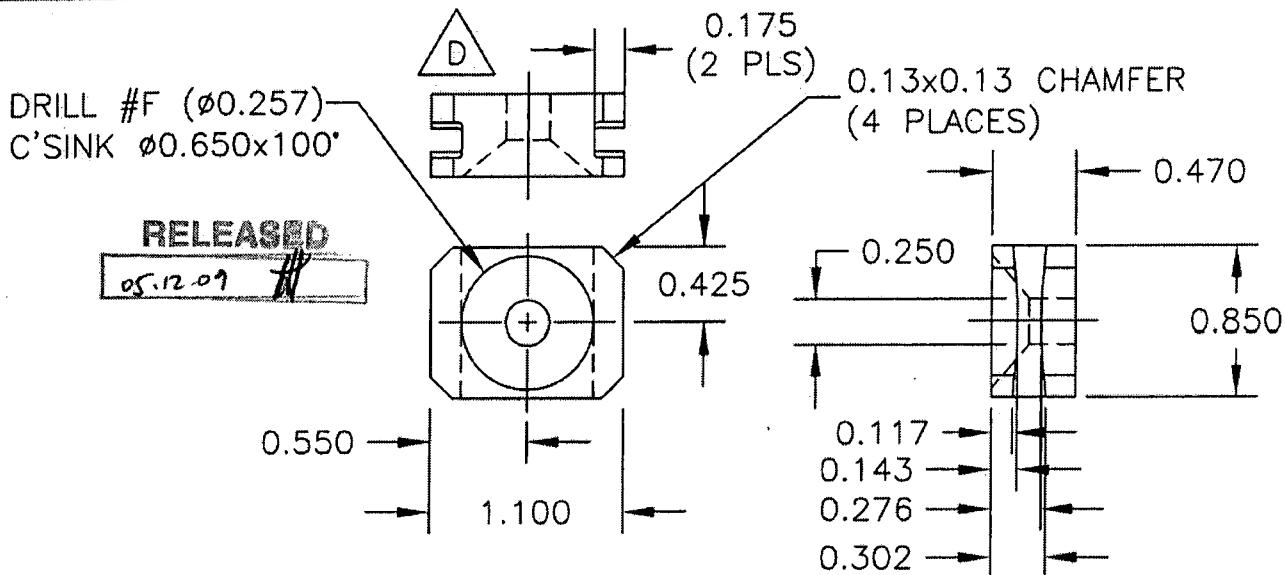
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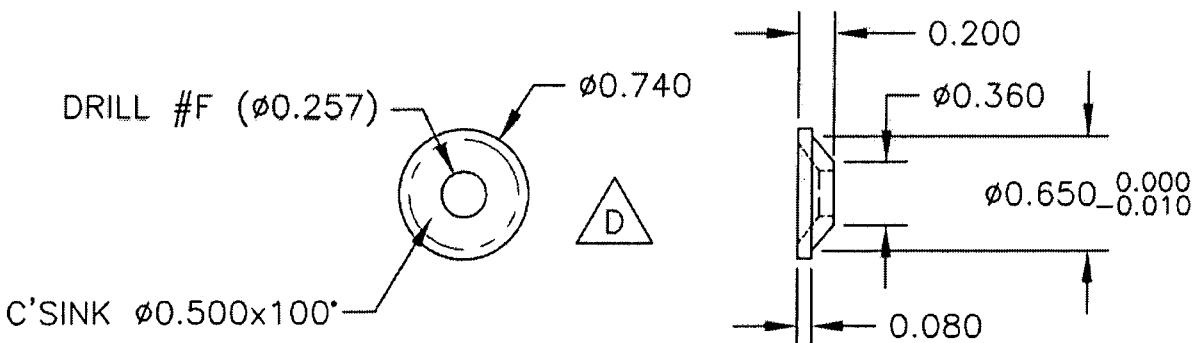
W. O'R. O'ROURKE  
NO. 25556 C

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DATE 05.11.23	TITLE BRACKET ASSEMBLY	SCALE 1:1	

**D3137-3 GUIDE**

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015

**D3137-5 WASHER**

- 1) REPLACES PREMIER P/N B30-23000-209
- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M6061T6R)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL EDGES 0.005 TO 0.015

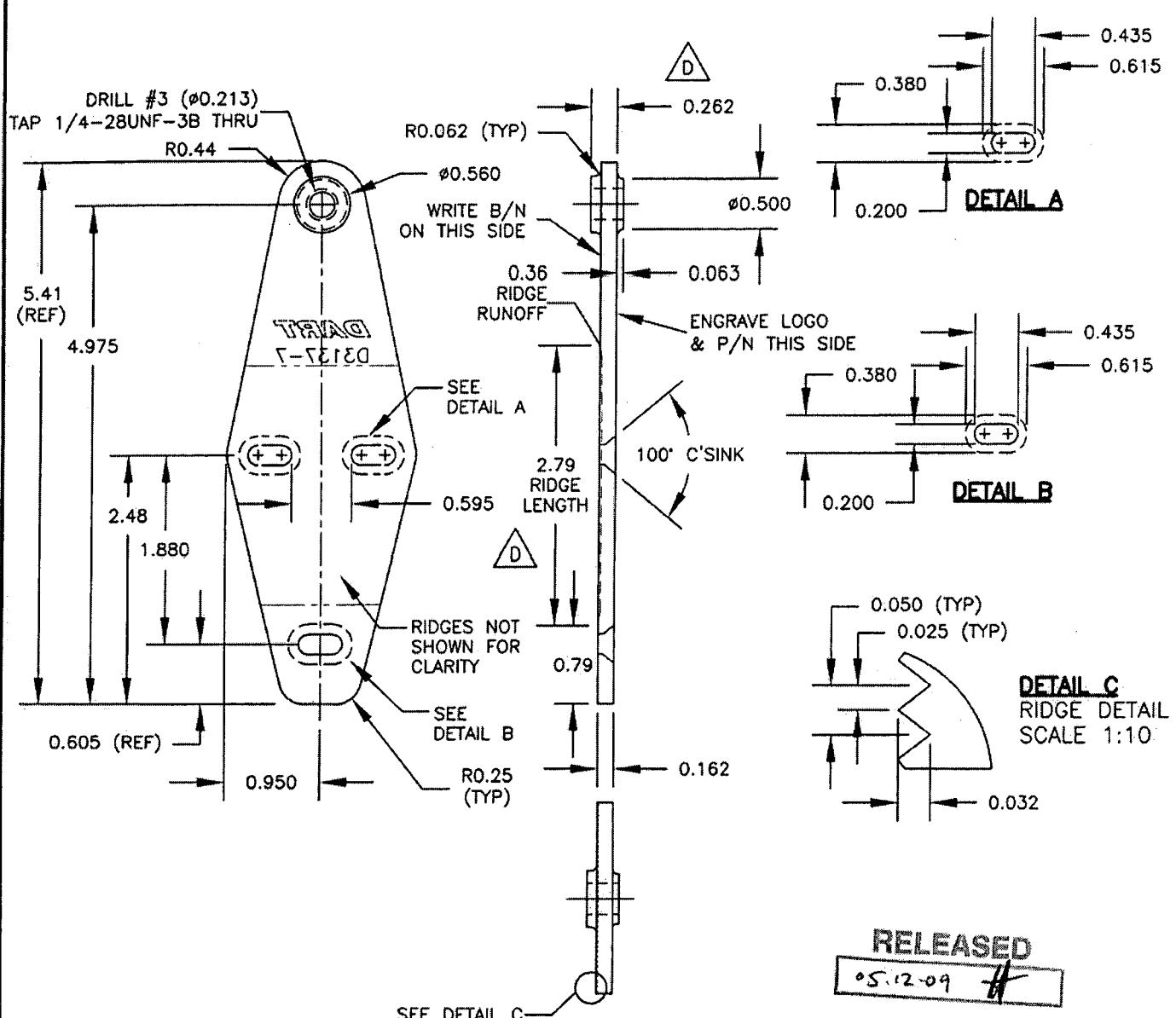
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DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 2:3



03137-7 BRACKET

- 1) MATERIAL: 17-4PH STAINLESS STEEL PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
  - 2) FINISH: NONE
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES
  - 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
  - 6) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010  
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
  - 7) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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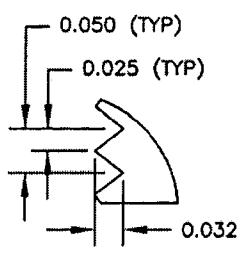
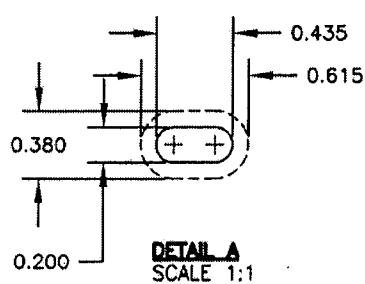
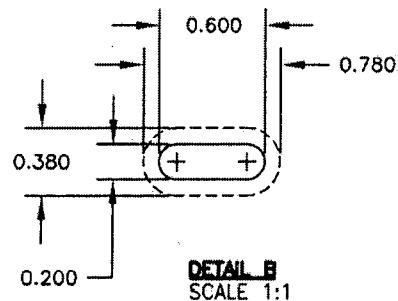
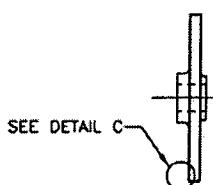
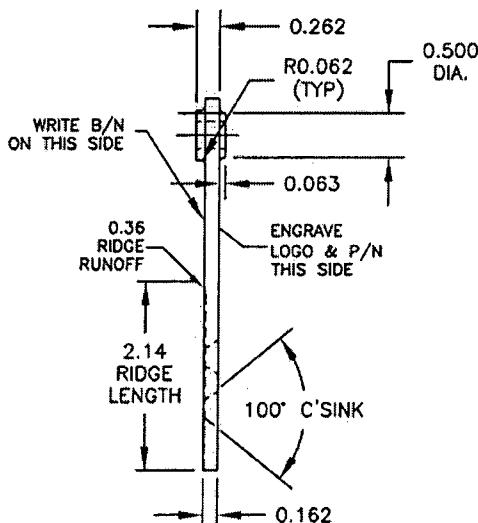
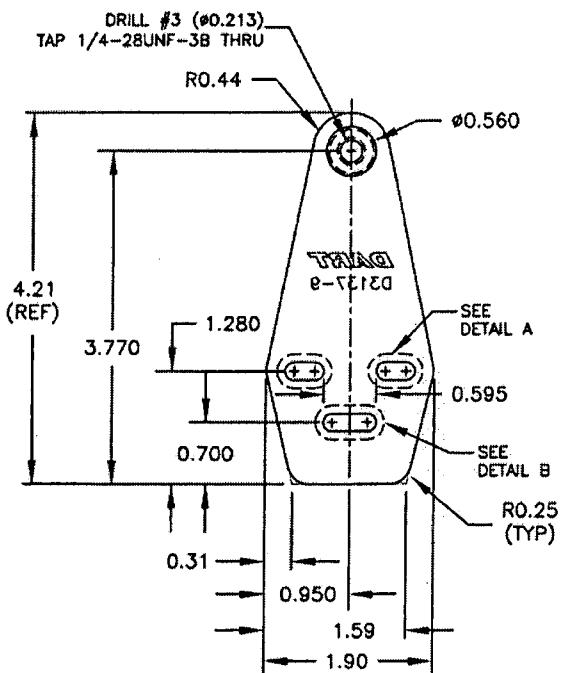
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DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:2

**DETAIL C**  
RIDGE DETAIL  
SCALE 1:20**DETAIL A**  
SCALE 1:1**DETAIL B**  
SCALE 1:1**D3137-9 BRACKET:**

- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
- 2) MATERIAL: 17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010  
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- 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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